Date: Wednesday, 8/8/2007 1:06:12 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: FLOAT SKID LH 206L1,L3,L4&407
Job Number	: 33849		
Estimate Number	: 10307		
P.O. Number	:	**Part Number**	: D206642511
This Issue	: 8/8/2007 **S.O. No.** :	**Drawing Number**	: N/A
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : LANDING GEAR	**Drawing Revision**	: K
Previous Run	: 33848	**Material**	:
Written By	: 07-08-08	**Due Date**	: 8/15/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	:		

Comment : Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
Est Rev:C 07-02-23 As per IIN D206-642 Rev K JLM
est rev D 07.06.06 added K642-511 EC

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile and create labels per PPP D206-642-511CHG003

2.0	33849A	FLOAT SKIDTUBE ASSEMBLY

Comment: Sub-Component FLOAT SKIDTUBE ASSEMBLY
D206-642-541 B____

3.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

4.0	K642 511	saddle kit 642-511

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
saddle kit 642-511
Batch:____________

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS

Form: rprocess

Date: Wednesday, 8/8/2007 1:06:12 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH 206L1,L3,L4&407

Job Number: 33849

Part Number: D206642511

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D206-642-511
Location:___________

Seq. #:	Machine Or Operation:	Description :
7.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

Date: Wednesday, 8/8/2007 1:08:07 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: FLOAT SKIDTUBE ASSEMBLY
Job Number	: 33849A		
Estimate Number	: 10309		
P.O. Number	:	**Part Number**	: D206642541
This Issue	: 8/8/2007 **S.O. No.** :	**Drawing Number**	: D3274 REV D
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : LANDING GEAR	**Drawing Revision**	: D
Previous Run	: 33848A	**Material**	:
Written By	: 07-08-08	**Due Date**	: 8/15/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	:		
Comment	: Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM Est Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPP D206-642-541 CHG003

2.0	D26001190	Extrusion Round 3" 206

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2600-1-190	3" OD Tube	D2484 07-08-09

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-1 to 190.00" in length as per Dwg D3274 and Deburr ends

2-Drill #40 Aft cap pilot hole using DT8025

3-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

4-Remove inner indexing ridge on aft end of skidtube as per Dwg D3274

5-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

07-08-09

Form: rprocess

Date: Wednesday, 8/8/2007 1:08:07 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 33849A

Part Number: D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Acid Etch and Alodine tube as per QSI 005 4.1

Seq. #:	Machine Or Operation:	Description :
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

Seq. #:	Machine Or Operation:	Description :
7.0	D3282041	I-Beam

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3282-041	Float Web	B-33656

Seq. #:	Machine Or Operation:	Description :
8.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Open Ø0.313" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Open Ø0.375" crossbolt spacer holes using DT8744 as per Dwg D3274

3-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

4-Bond web in place as per Dwg D3274 & QSI 015.
A/R Sikaflex-291
Sikaflex expire date:
Start: Time:
Finish: Time:
(Adhere for 12 hours)

Seq. #:	Machine Or Operation:	Description :
9.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

Form: rprocess

Date: Wednesday, 8/8/2007 1:08:07 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 33849A
Part Number: D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
10.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Bend tube using program D3274 as per Dwg D3274. Install drop pins in cross bolt spacer holes to maintain web position.

2-Cut Fwd end of tube to length as per Dwg D3274

3-Remove inner indexing ridge on Fwd end of skidtube as per Dwg D3274

4- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297"

5-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE
'DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

6- Countersink crossbolt spacer holes as per Dwg D3274

PTO

See last page.

Seq. #:	Machine Or Operation:	Description :
11.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

Seq. #:	Machine Or Operation:	Description :
12.0	D32851	Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3285-1	Fwd Cap	________

Scrap

Seq. #:	Machine Or Operation:	Description :
13.0	D2649	Crossbolt Spacer

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
12	D2649	Crossbolt spacer	________

Form: rprocess

Date: Wednesday, 8/8/2007 1:08:07 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 33849A

Part Number: D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
14.0	D32751	Crossbolt Spacer

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
12	D3275-1	Crossbolt spacer	________

Seq. #:	Machine Or Operation:	Description :
15.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod.
A/R Aluminum Rod ________

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod
A/R Aluminum Rod ________

3-Grind welds flush to Fwd cap on top surface only.

4-Grind cross bolt welds flush as per Dwg D3274. Masking Tape access to inside of the skidtube

5-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

Seq. #:	Machine Or Operation:	Description :
16.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

Seq. #:	Machine Or Operation:	Description :
17.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION

Scrap

Seq. #:	Machine Or Operation:	Description :
18.0	POWDER COATING	POWDER COATING

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Seq. #:	Machine Or Operation:	Description :
19.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Form: rprocess

Date: Wednesday, 8/8/2007 1:08:07 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 33849A

Part Number: D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
25.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP
Inspect Nut Plate & Inserts

Seq. #:	Machine Or Operation:	Description :
26.0	AN3C4A	BOLT

Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)
BOLT
Batch:______________

Seq. #:	Machine Or Operation:	Description :
27.0	D353515	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch:______________

Seq. #:	Machine Or Operation:	Description :
28.0	D353523	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch:______________

Seq. #:	Machine Or Operation:	Description :
29.0	D353535	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch:______________

Scrap

Seq. #:	Machine Or Operation:	Description :
30.0	D353539	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch:______________

Seq. #:	Machine Or Operation:	Description :
31.0	D353615	GASKET

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch:______________

Form: rprocess

Date: Wednesday, 8/8/2007 1:08:07 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** FLOAT SKIDTUBE ASSEMBLY

Job Number: 33849A **Part Number:** D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
32.0	D353623	GASKET

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch:_________________

Seq. #:	Machine Or Operation:	Description :
33.0	D353635	GASKET

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch:_________________

Seq. #:	Machine Or Operation:	Description :
34.0	D353639	GASKET

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch:_________________

Seq. #:	Machine Or Operation:	Description :
35.0	D35371	WEARPAD

Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)
WEARPAD
Batch:_________________

Seq. #:	Machine Or Operation:	Description :
36.0	D35373	WEARPAD

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPAD

Seq. #:	Machine Or Operation:	Description :
37.0	AN960C10L	washer

Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
80	AN960C10L	Washer	__________

Seq. #:	Machine Or Operation:	Description :
38.0	NAS1515H3L	WASHER

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	__________

Scrap

Form: rprocess

Date: Wednesday, 8/8/2007 1:08:07 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 33849A
Part Number: D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
39.0	D34131	Ring

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3413-1	Ring	__________

Seq. #:	Machine Or Operation:	Description :
40.0	AN4C5A	BOLT

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	AN4C5A	Bolt	__________

Seq. #:	Machine Or Operation:	Description :
41.0	AN960C416	washer

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	AN960C416	Washer	__________

Seq. #:	Machine Or Operation:	Description :
42.0	D2646	Aft Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	__________

Scrap

Seq. #:	Machine Or Operation:	Description :
43.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

2-Install wearpads & gaskets as per Dwg D3274.

3-Install ring as per Dwg D3274
A/R Sikaflex-291 __________
Sikaflex expire date: __________

4-Inspect for foreign objects as per QSI 024

5-Spray inside of tube on both sides of web with LPS-3
A/R LPS-3 Batch:__________

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

Form: rprocess

Date: Wednesday, 8/8/2007 1:08:07 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 33849A

Part Number: D206642541

Job Number:

Seq. #:	Machine Or Operation:	Description :
	A/R Sikaflex-291 ________ Sikaflex expire date: ________	
44.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	
45.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and stock Location:________	
46.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	

Job Completion

Scrap 2008-09-25

Form: rprocess

DART

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3274 — REV. D — SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY — SCALE NTS

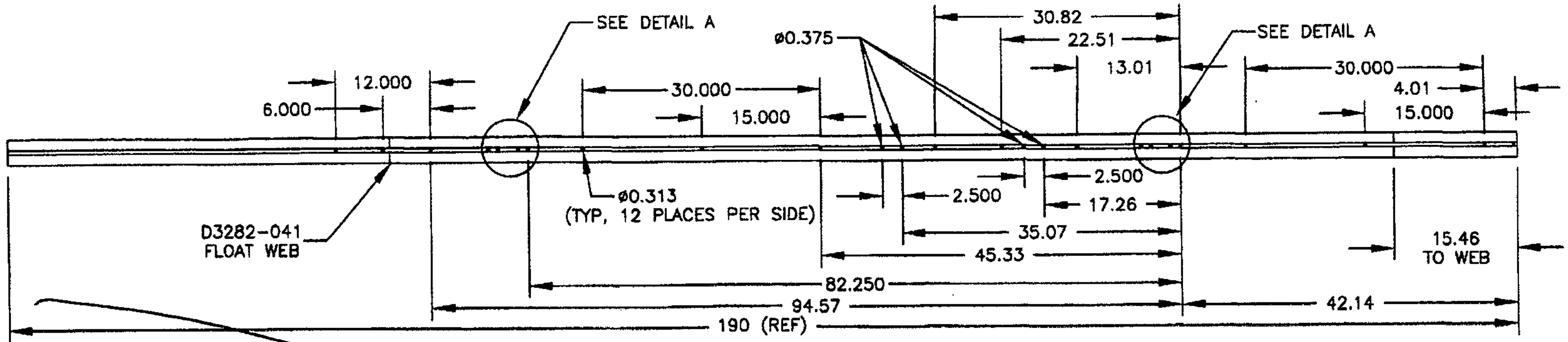
A	04.03.15	NEW ISSUE
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76
C	05.03.16	ADD –043; NEW INSERTS
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET

RELEASED 07.02.12

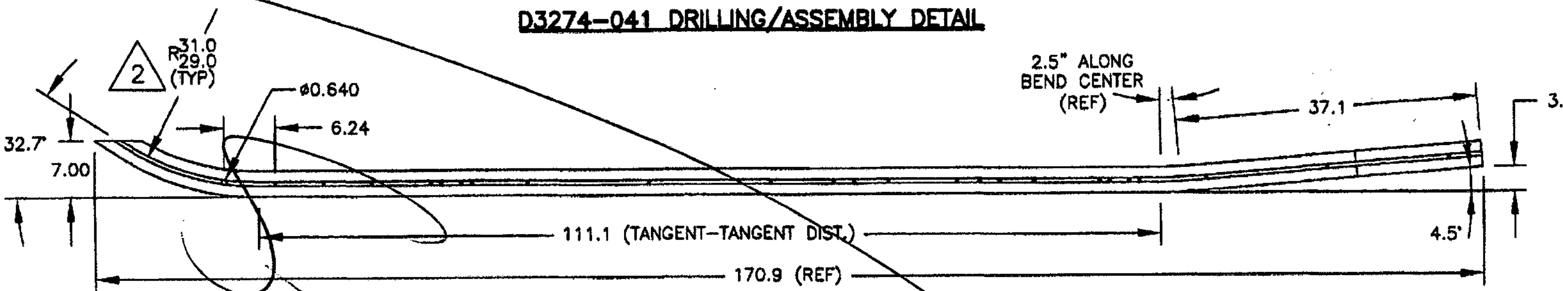
Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

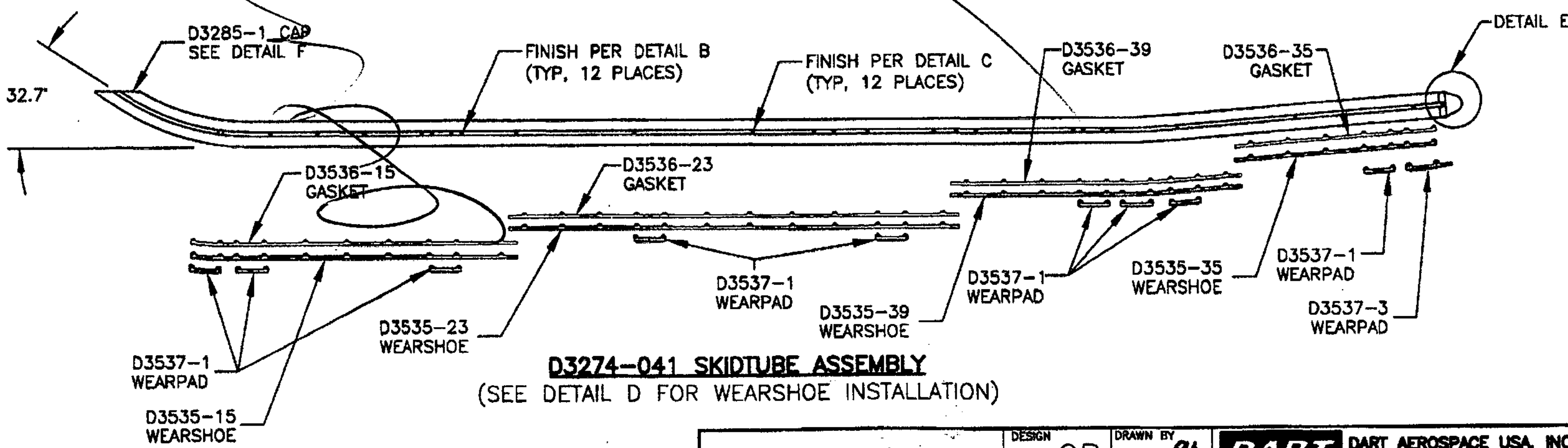
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
   THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
   - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL

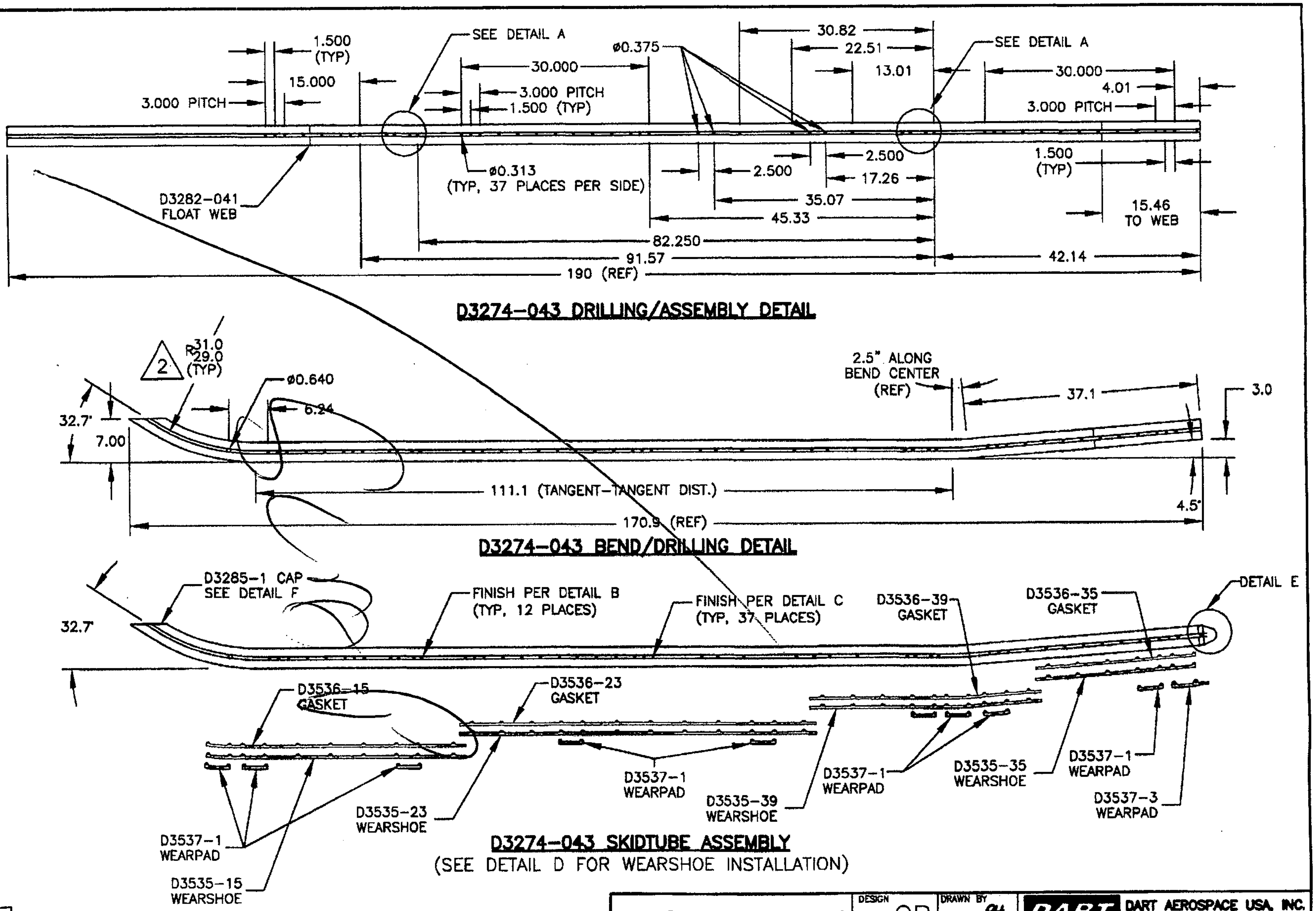


D3274-041 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

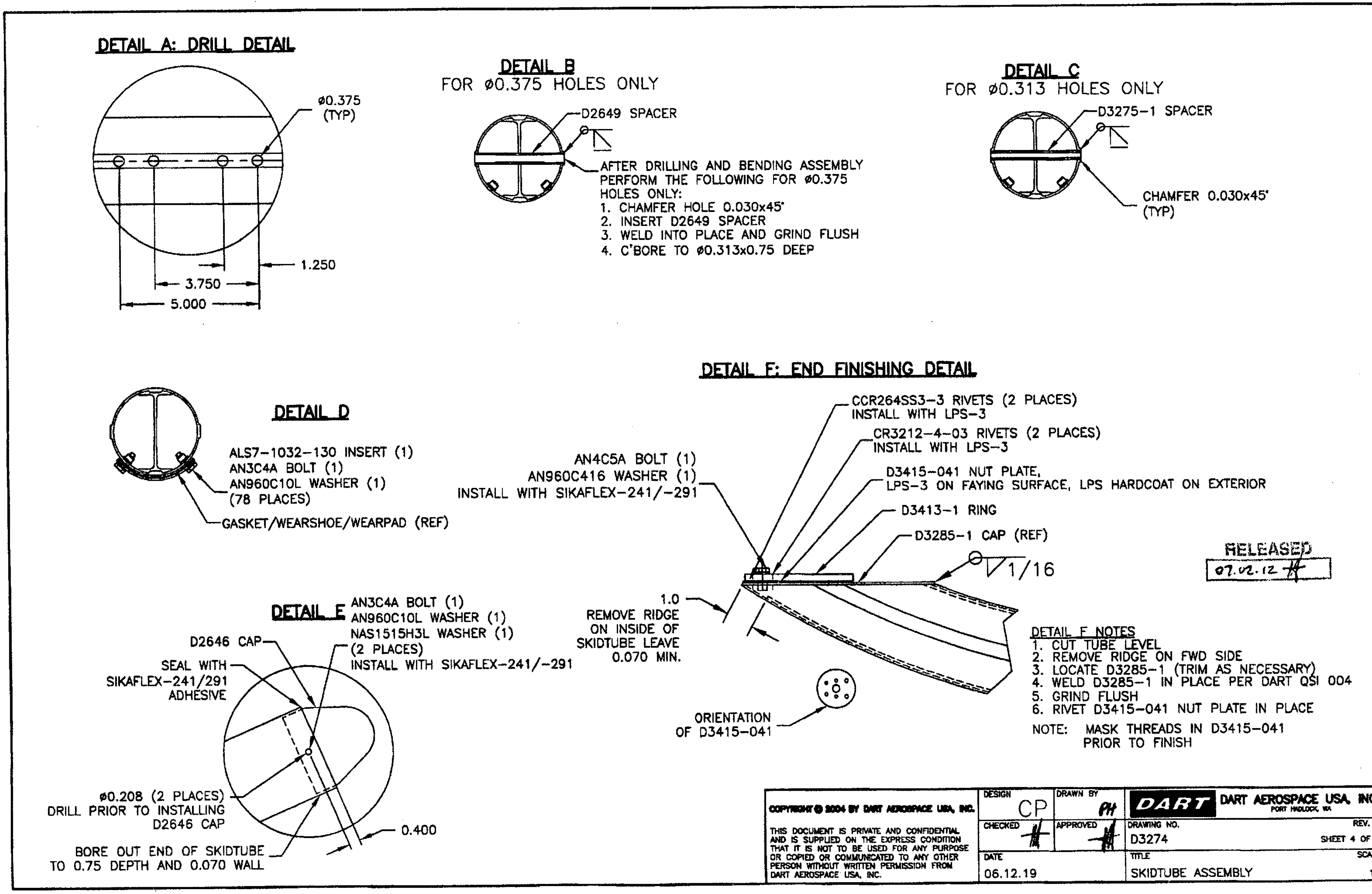
RELEASED
07.02.12

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CP	PH		
CHECKED	APPROVED	DRAWING NO. D3274	REV. D SHEET 2 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE 1:15



RELEASED 07.02.12

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CP	PH	
CHECKED	APPROVED	DRAWING NO. D3274 — REV. D — SHEET 3 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY — SCALE 1:15


DETAIL A: DRILL DETAIL
ø0.375 (TYP)
1.250
3.750
5.000
DETAIL B
FOR ø0.375 HOLES ONLY
D2649 SPACER
AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO ø0.313x0.75 DEEP
DETAIL C
FOR ø0.313 HOLES ONLY
D3275-1 SPACER
CHAMFER 0.030x45° (TYP)
DETAIL D
ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)
DETAIL F: END FINISHING DETAIL
CCR264SS3-3 RIVETS (2 PLACES) INSTALL WITH LPS-3
CR3212-4-03 RIVETS (2 PLACES) INSTALL WITH LPS-3
AN4C5A BOLT (1)
AN960C416 WASHER (1)
INSTALL WITH SIKAFLEX-241/-291
D3415-041 NUT PLATE, LPS-3 ON FAYING SURFACE, LPS HARDCOAT ON EXTERIOR
D3413-1 RING
D3285-1 CAP (REF)
1/16
RELEASED
07.02.12
1.0
REMOVE RIDGE ON INSIDE OF SKIDTUBE LEAVE 0.070 MIN.
ORIENTATION OF D3415-041
DETAIL F NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH
DETAIL E
AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291
D2646 CAP
SEAL WITH SIKAFLEX-241/291 ADHESIVE
ø0.208 (2 PLACES) DRILL PRIOR TO INSTALLING D2646 CAP
BORE OUT END OF SKIDTUBE TO 0.75 DEPTH AND 0.070 WALL
0.400
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DESIGN CP
DRAWN BY PH
CHECKED
APPROVED
DATE 06.12.19
DART
DART AEROSPACE USA, INC.
PORT HADLOCK, WA
DRAWING NO. D3274
REV. D
SHEET 4 OF 4
TITLE SKIDTUBE ASSEMBLY
SCALE 1:3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ________ **Fault Category:** ________ **NCR:** Yes No **DQA:** ______ **Date:** ________

QA: N/C Closed: ______ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
07.09.20	10.2	Tube is 2.75" too short on the total length, & Fwd height. R.C: Employee set-up the saw incorrectly for the fwd cut. Human error.	[signature] 07/09/19	Tube is scrap.	EZ 7-9-25	[signature] 07/09/25	[signature] 07/09/19	[signature] 07.09.19

NOTE: Date & initial all entries

8868